



Dart Aerospace Ltd.
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K6A 1K7
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D5550-043
Job Sheet 186832



Part No: D5550-043

Job Qty: 2 ea

Part Name: Aft Outboard Beam Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5550 REV.A IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP

Ship Via:

7270

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Small Fab-4	88 09:30	JAN 02 2019
110	Small Fab	2 pcs	12/7/18	12/7/18	0.00	0.52	Small Fab-9	36	36 DAS
120	QC	2 pcs	12/7/18	12/7/18	0.00	0.00	QC5	9-80	30
130	Packaging	2 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2	5477	JAN 08 2019
140	QC21-SA	2 Ea	12/7/18	12/7/18	0.00	0.00	QC21	21	JAN 08 2019

Part Op 110 - 1- Install plate loose to D5550-3 2- Add spacer and eyebolt stud. 3- Torque nuts as per dwg and notes 8,9

Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C13A	Bolt	16 Ea (8 ea)	90-Start up Operation	5104358
AN4C13A	Bolt	4 Ea (2 ea)	90-Start up Operation	5103692
D4148-3	Stud Receiver, Lower	2 Ea (1 ea)	90-Start up Operation	5140477
D4148-5	Eyebolt Stud	2 Ea (1 ea)	90-Start up Operation	5119723
D5550-3	Aft Outboard Beam	2 Ea (1 ea)	90-Start up Operation	5117916
D5551-3	Aft Support Plate	4 Ea (2 ea)	90-Start up Operation	5040511
D5552-3	Spacer	2 Ea (1 ea)	90-Start up Operation	5036050
MS20615-4M18	Rivet	30 Ea (15 ea)	90-Start up Operation	5109967
MS21043-3	Nut	16 Ea (8 ea)	90-Start up Operation	5109966
MS21043-4	Nut	4 Ea (2 ea)	90-Start up Operation	5092790
NAS1149C0363R	Washer	32 Ea (16 ea)	90-Start up Operation	5132615
NAS1149C0432R	Washer	8 Ea (4 ea)	90-Start up Operation	5103990

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C13A	16	47	0
	AN4C13A	4	164	0
	D4148-3	2	0	0
	D4148-5	2	21	0
	D5550-3	2	2	0
	D5551-3	4	6	0
	D5552-3	2	9	0
	MS20615-4M18	30	205	0
	MS21043-3	16	852	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord ☐ Rec/St ☐ Engineering ☐ Quality ☐ Design ☐			
Date : _____		Step #: _____		QTY Effective : _____			
Description Work Order Deviation				Disposition			

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

DART AEROSPACE
 Container No: S141202
 Part: D5550 - 043
 Job No: 186832
 Serial No/ Batch: S141202
 Revision: A
 Inspector:
 Exp Date:
 Instructions: Various STC's
 Date: 01/02/19
 DART Aerospace Ltd.
 1270 Aberdeen Street
 Haverhill, ON M6A 1K7
 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaero.com
 QC/QA Control
 Approval

MS21043-4
NAS1149C0363R
NAS1149C0432R

4
32
8

763
199
1,826

0
0
0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
QC / QA Coordinator Approval																					
Root Cause			FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					